

Date:
User:Friday, 9/15/2006 12:00:29 PM
Kim Johnston

Process Sheet

SLIT

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 28619
Estimate Number : 11156
P.O. Number : N/A
This Issue : 9/15/2006 **S.O. No.** : N/A
Prsht Rev. : NC
First Issue : N/A **Type** : PURCHASED PARTS
Previous Run : N/A
Written By :
Checked & Approved By :
Comment : Est. A 88.03.03 New issue KJ/JLM

Drawing Name : TIRE AND RIM ASSEMBLY
Part Number : D32339
Drawing Number : D3233 REV B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 9/30/2006 **Qty:** 20 **Um:** Each

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 2062

C Lde 109/18 (20)

For D3233-9 Tire and Rim Assembly P/N: 8353T74

Possible Supplier: McMaster-Carr

Product Specification sheet is required

2.0 8353T74 TIRE & RIM



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
Tire & Rim Assembly

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure Product Specification sheet is attached

Identify and Stock

Location: _____

4.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



06/09/22
U 0609-22

DLG

U

06-09-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

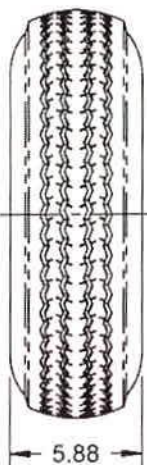
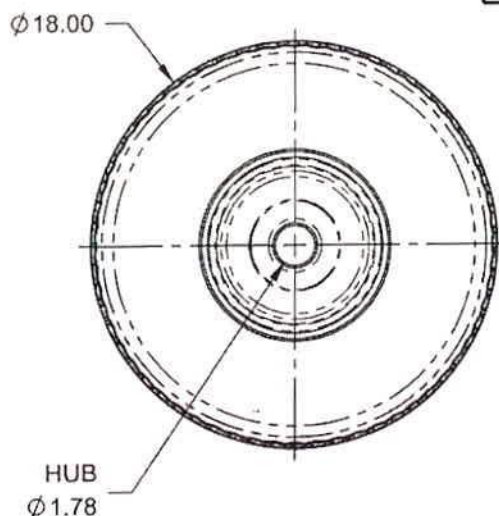
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/09/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



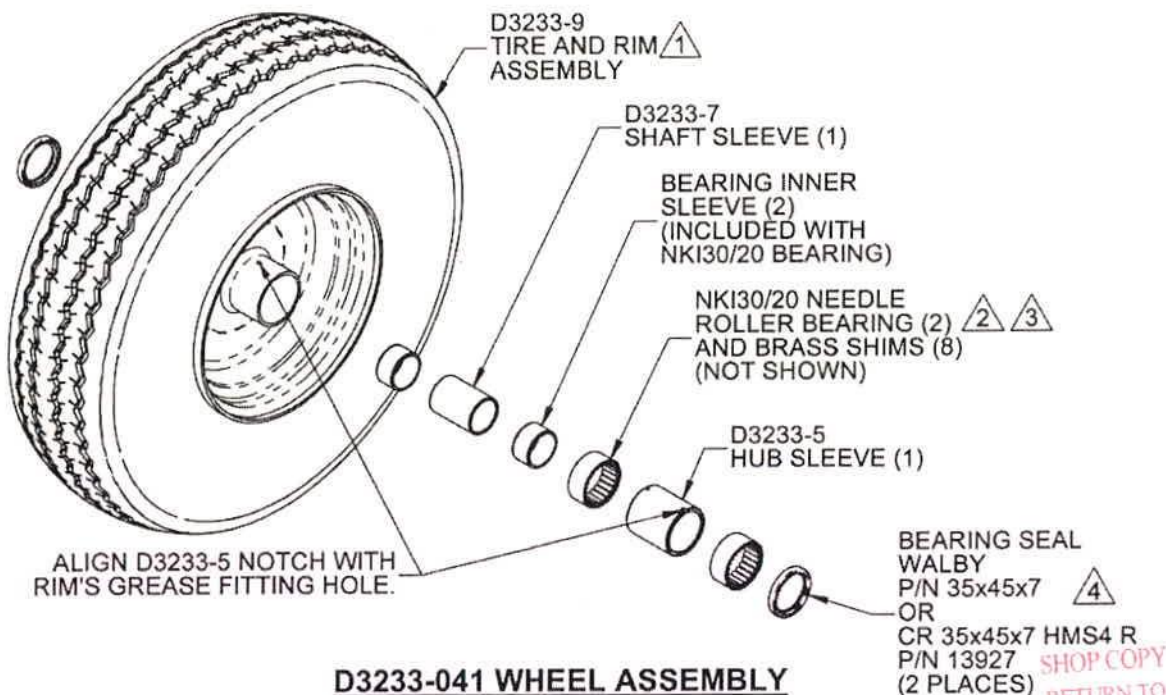
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	



RELEASED
[Signature]
05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

* MANUFACTURER'S RECOMMENDATIONS ARE 75 PSI FOR HIGH SPEED USE.



D3233-041 WHEEL ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH (4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

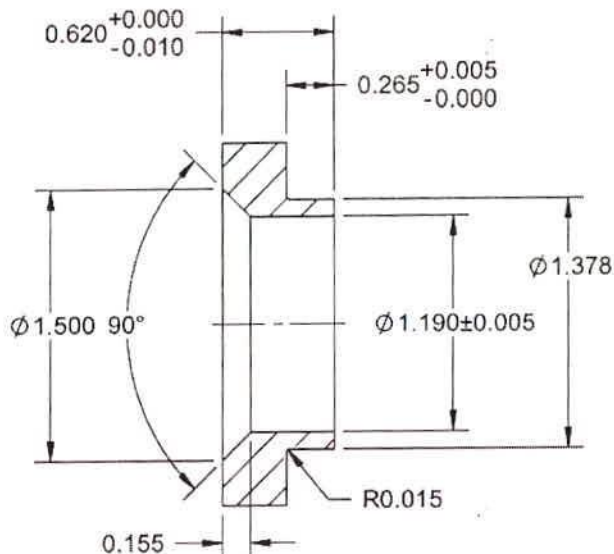
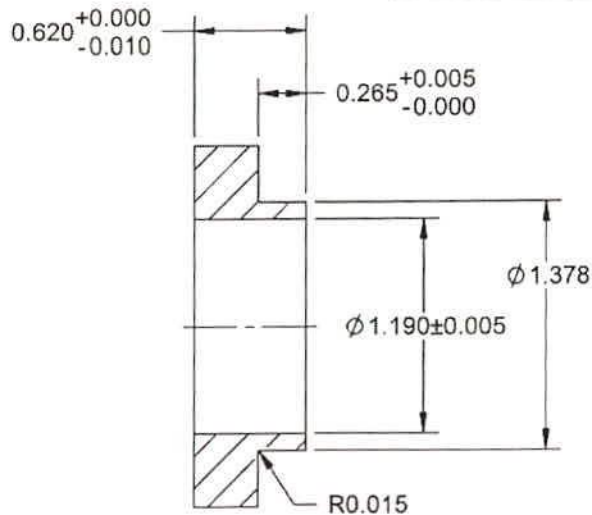
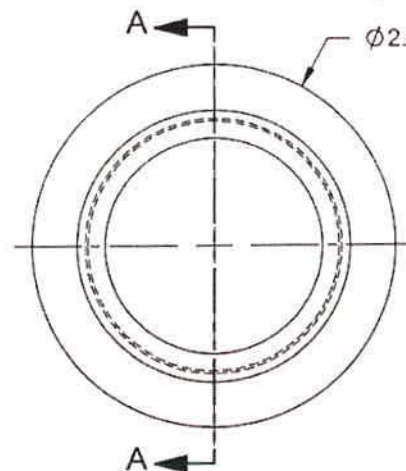
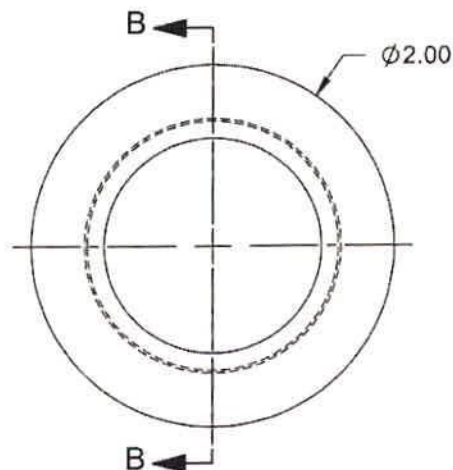
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NO. 28619

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 2 OF 3
DATE 05.03.08	TITLE WHEEL ASSEMBLY	SCALE 1:1	

**SECTION A-A****D3233-1 INSIDE WASHER****SECTION B-B****D3233-3 OUTSIDE WASHER****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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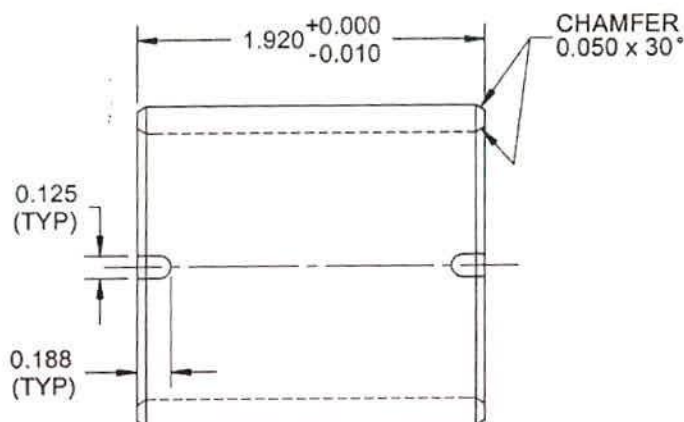
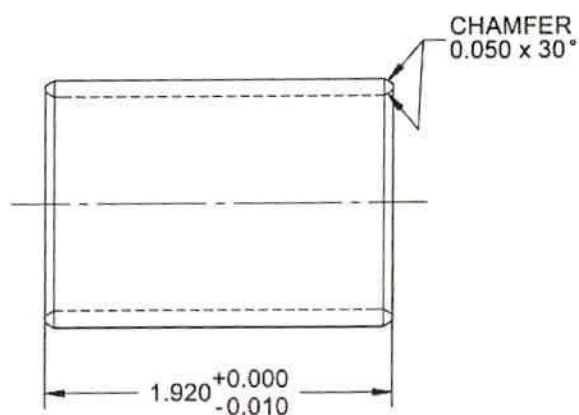
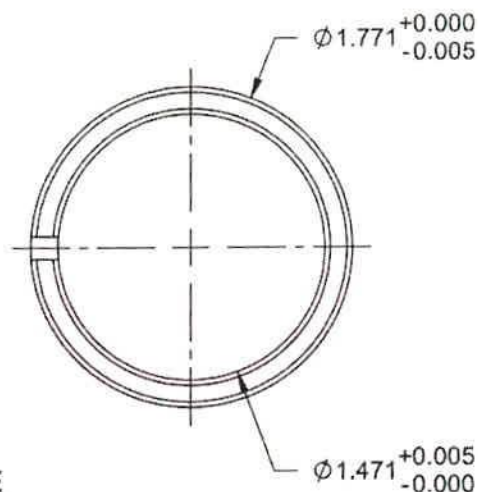
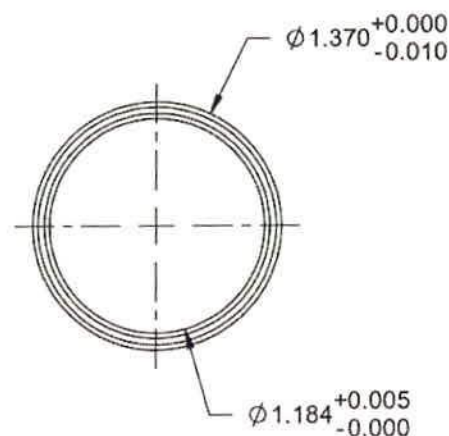
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DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

RELEASED
[Signature]
05/05/04**D3233-5 HUB SLEEVE****D3233-7 SHAFT SLEEVE****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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3

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY

ON

K6A 1

**YOUR PURCHASE
ORDER NUMBER**

P02062

Today's Date: 9/18/06

MCMASTER-CARR
200 AURORA INDUSTRIAL PKWY
AURORA OH 44202

IF THERE ARE ANY QUESTIONS ABOUT THIS
SHIPMENT CONTACT OUR SALES DEPARTMENT
(330)995-5500

PAGE**1 OF 1****MCM NUMBER**

3958952-01

Warehouse Location	McMaster Carr Part Number	Fill Quantity	Item Description	Your Line	Your Order	This Shipment
8- 69-53	63-64 8355 T74	8 EA	PNEUMATIC WHEEL WITH WELDED RIMS 19"DIA X 5.8"W, 1-1/4"AXLE, ROLLER BRNG, 1590# CAP 121 PAK Balance of 12 EA shipped today from another McMaster-Carr warehouse	1	20 EA	8

533

2

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY

DN

K6A 1

YOUR PURCHASE
ORDER NUMBER

P02062

Today's Date: 9/18/06

MCMASTER-CARR
200 AURORA INDUSTRIAL PKWY
AURORA OH 44202IF THERE ARE ANY QUESTIONS ABOUT THIS
SHIPMENT CONTACT OUR SALES DEPARTMENT
(330)995-5500

PAGE

1 OF 1

MCM NUMBER

3958952-02

Warehouse Location	McMaster Carr Part Number	Fill Quantity	Item Description	Your Line	Your Order	This Shipment
8- 9-48 24-47	8353 T74	12 EA	PNEUMATIC WHEEL WITH WELDED RIMS 19"DIA X 5.8"W, 1-1/4"AXLE, ROLLER BRNG, 1590# CAP 182 RAS Balance of 8 EA shipped today from another McMaster-Carr warehouse	1	20 EA	12

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